

Tuesday, June 09, 2015 3:06:17 PM

133021

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/22/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/5/2015 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MF. Date: 15-6-9 Tooling: Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001-45	c

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Align drill -97 and -357 using existing pilot hole of -357 as per dwg

2- install spring pin

110⁴

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Green Sandtex(Ref:4.3.5.8) per OSI005 4.3

0.00

120

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPE

FINISH TIME:

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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OTHER : ☐																					

Work Order ID 133021

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133021

Page 3

Item ID: PB67-43001-45

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Longitudinal Support

Start Date: 5/22/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/5/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: WA3

0.00

160

Packaging

Memo

0.00

Packaging

1JUN 23 2015 DAS
24
9-89

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MCJ JUN 24 2015WIS-0624

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
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Picklist Print

Tuesday, June 09, 2015 3:06:15 PM

Page 1

Work Order ID: 133021

133021

Parent Item: PB67-43001-45

PR67-43001-45

Parent Item Name: Longitudinal Support

Start Date: 5/22/2015

Required Date: 6/5/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-25 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-97		Manufactured	No			100	Each	2.0000	1	1			

PR67-43001-97

Clevis

Location	Loc Qty	Loc Code
Mezz2	2	
110589	1	
90890	1	

PB67-43001-357

Manufactured No

100 Each 2.0000 1

1

PR67-43001-357

Tube Arm

Location	Loc Qty	Loc Code
Mezz2	2	
41508	2	

240-107

Purchased No

100 Each 176.0000 1

1

240-107

SPRING SLOTTED PIN

JUN 23 2015

DAS
24
9-89

Location	Loc Qty	Loc Code
ST568	176	
m132006	176	

D3447-1

Manufactured No

140 Each 6.0000 1

1

D3447-1

Round Spacer

Location	Loc Qty	Loc Code
Mezz2	6	
113397	6	

MF 15-6-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Picklist Print

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Page 2

Work Order ID: 133021

133021

Parent Item: PB67-43001-45

PB67-43001-45

Parent Item Name: Longitudinal Support

Start Date: 5/22/2015

Required Date: 6/5/2015

Start Qty: 1.00

Required Qty: 1.00

D3447-5 Manufactured No

140 Each 3.0000 1 1

D3447-5

Clevis

Location

Loc Qty

Loc Code

Mezz2

3

110603

3

30345T21 Purchased No

140 Each 19.0000 1 1

30345T21

LANYARD

ME 15-6-11

JUN 23 2015

DAS
24
9-89

Location

Loc Qty

Loc Code

ST570

19

M127979

19

AN4-13A Purchased No

140 Each 452.0000 1 1

AN4-13A

Bolt

JUN 23 2015

DAS
24
9-89

Location

Loc Qty

Loc Code

FG

20

122808

20

ST325A

408

m131957

200

m132317

208

ST344

24

131677

24

BSP43 Purchased No

140 Each 43.0000 1 1

RSP43

RIVET

JUN 23 2015

DAS
24
9-89

Location

Loc Qty

Loc Code

ST551

43

M128636

43

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Shop Packet Print

Page 2

DQA: _____ Date: _____



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Picklist Print

Tuesday, June 09, 2015 3:06:16 PM

Page 3

Work Order ID: 133021

133021

Parent Item: PB67-43001-45

PR67-43001-45

Parent Item Name: Longitudinal Support

Start Date: 5/22/2015

Required Date: 6/5/2015

Start Qty: 1.00

Required Qty: 1.00

MS17984-C410

Purchased

No

140

Each

29.0000

1

1

JUN 23 2015

**DAS
24
9-89**

MS17984-C410

QUICK PIN REPLACEMENT

Location

Loc Qty

Loc Code

ST315

29

m127924

13

m128051

16

MS21042L4

Purchased

No

140

Each

5,133.000

1

1

JUN 23 2015

**DAS
24
9-89**

MS21042L4

Locknut

Location

Loc Qty

Loc Code

FP001

26

m124231

26

GA

208

m127813

208

ST260a

4062

m130799

56

m131803

6

m132262

1000

m132382

3000

ST305

837

m128300

8

m130388

7

m130922

97

m131618

24

m132123

701

NAS1149D0416J

Purchased

No

140

Each

4,800.000

2

2

JUN 23 2015

**DAS
24
9-89**

NAS1149D0416J

WASHER

Location

Loc Qty

Loc Code

ST270

4800

m131511

4800

Tuesday, June 09, 2015 3:06:16 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

Tuesday, June 09, 2015 3:06:16 PM

Page 4

Work Order ID: 133021

133021

Parent Item: PB67-43001-45

PB67-43001-45

Parent Item Name: Longitudinal Support

Start Date: 5/22/2015

Required Date: 6/5/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN416J

Purchased

No

140

Each

816.0000

1

1

NAS1149DN416.J

JUN 23 2015

**DAS
24
9-89**

Washer

Location

Loc Qty

Loc Code

GA

118

124983

118

ST270

698

124968

698

DQA: _____ Date: _____

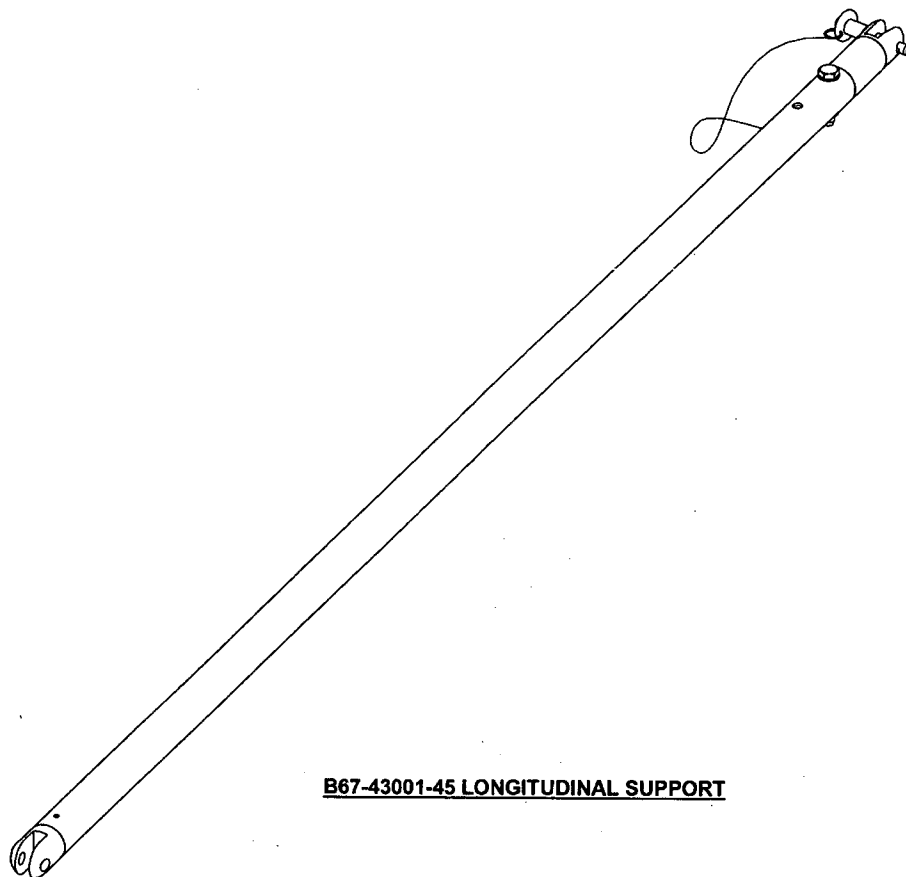


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER :																																																																				



B67-43001-45 LONGITUDINAL SUPPORT

ITEM	QTY -45	P/N	DESCRIPTION
1	X	B67-43001-45	LONGITUDINAL SUPPORT
3	1	B67-43001-97	CLEVIS
4	1	B67-43001-357	TUBE ARM
5	1	D3447-1	ROUND SPACER
6	1	D3447-5	CLEVIS
8	1	30345T21	LANYARD
9	1	AN4-13A	BOLT
10	1	CR3213-4-2	RIVET (OR BSP43-2)
11	1	MS17984-C410	QUICK RELEASE PIN
12	1	MS21042L4	NUT
13	1	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)
14	2	NAS1149D0416J	WASHER
15	1	NAS1149DN416J	WASHER

mf
#13021

RELEASED
2009-09-24
mf

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 13 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.25
REV.	DESCRIPTION		BY	DATE
DESIGN	R/W	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED	ASS	DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-45	SHEET 1 OF 2	
APPROVED	MP	TITLE	SCALE	
DE APPR.	N/A	LONGITUDINAL SUPPORT	NTS	
DATE	09.06.25	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

B67-43001-97
2 CLEVIS

B67-43001-357
2 TUBE ARM

10 CR3213-4-2 RIVET
NAS1149DN416J WASHER
(30345T21 LANYARD NOT SHOWN
ON THIS VIEW FOR CLARITY)

D3447-1
ROUND SPACER

AN4-13A BOLT
NAS1149D0416J WASHER, 2X
MS21042L4 NUT

0.50
8

MS171534 2 8
SPRING SLOTTED TENSION PIN

10 30345T21 LANYARD

MS17984-C410
QUICK RELEASE
PIN

9
2 PL

D3447-5
CLEVIS

B67-43001-45 LONGITUDINAL SUPPORT

RELEASED
2009-09-24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs
- 8) PRIOR TO POWDER COAT, ALIGN B67-43001-97 ON B67-43001-357 AS SHOWN AND DRILL A $\phi 0.129$ HOLE THROUGH BOTH PARTS.
FASTEN B67-43001-97 TO B67-43001-357 USING MS171534 SPRING SLOTTED PIN.
- 9) MASK PRIOR TO POWDER COAT
- 10) BEFORE OR AFTER POWDER COAT, DRILL A $\phi 0.129$ HOLE IN B67-43001-357 TO INSTALL THE LANYARD. DRILL THROUGH ONE WALL ONLY.
AFTER POWDER COAT, INSTALL 30345T21 LANYARD ON B67-43001-357 AS SHOWN USING CR3213-4 TYPE RIVET AND NAS1149DN416J WASHER.

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AD	B67-43001-45	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	LONGITUDINAL SUPPORT	NTS
DATE	09.06.25	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					